

Work Order ID 87046

July-10-12 2:18:56 PM

87046

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Item ID: D3705-11 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: MAIN PANEL
 Start Date: 7/10/12 Start Qty: 2.00 *2* Cust Item ID:
 Required Date: 7/10/12 Req'd Qty: 2.00 *2* Customer:
 Reference:

Approvals: Process Plan: ✓ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3705	D					(3)			
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	0.00							B12-7-10
FLOW CNC Waterjet	1-Cut as per Dwg D3705								
6061 . 063	Dwg Rev: <u>B</u>								
	Prog Rev: <u>B</u>								
	2- Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							B12-7-10
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00							876214
Quality Control						(4)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item Name: MAIN PANEL
Start Date: 7/10/12 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 7/10/12 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Small Fab	Small Fab	0.00							
Small Fab	Memo Deburr if necessary.	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00							
Quality Control	Memo	0.00							
150 *150* HandFinish	Chemical Conversion Coat per QSI005 4.1	0.00							
Hand Finishing	Memo	0.00							

✓ 7/16 12-7-11

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N900040100

Setup Start *NS1*

Stop *NS2*

2

?

Reference:

Run Start *NR1*

Stop ***NR2***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

160

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

170

QC3- Inspect Part Finish

0.00

170

QC

Quality Control

Memo

0.00

180

Identify as per dwg & Stock Location: 734

0.00

180

Packaging

Packaging

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Item ID: D3705-11

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: MAIN PANEL

Start Date: 7/10/12

Start Qty: 2.00

2

Cust Item ID:

Required Date: 7/10/12

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190

QC21- Final Inspection - Work Order Release

0.00

190

QC

Memo

0.00

Quality Control

MLJ 12/07/11

MLJ 12/07/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Page 1

Work Order ID: 87046

Parent Item: D3705-11

Parent Item Name: MAIN PANEL

Start Date: 7/10/12

Required Date: 7/10/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 09-01-09 rev.c as per dwg DD verified by:EC IPP Rev:B as per dwg RevD DD
10.04.27 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	490.9868	0.35	0.7368421	2.00	2	

Location

Loc Qty

Loc Code

MAT021

490.9868320

113608

0

116308

5.01556842

117285

67.544

119331

44.2

119802

5.94

120218

15.86

120866

64.8126316

121805

287.614632

121578

121579

Dart Aerospace Ltd

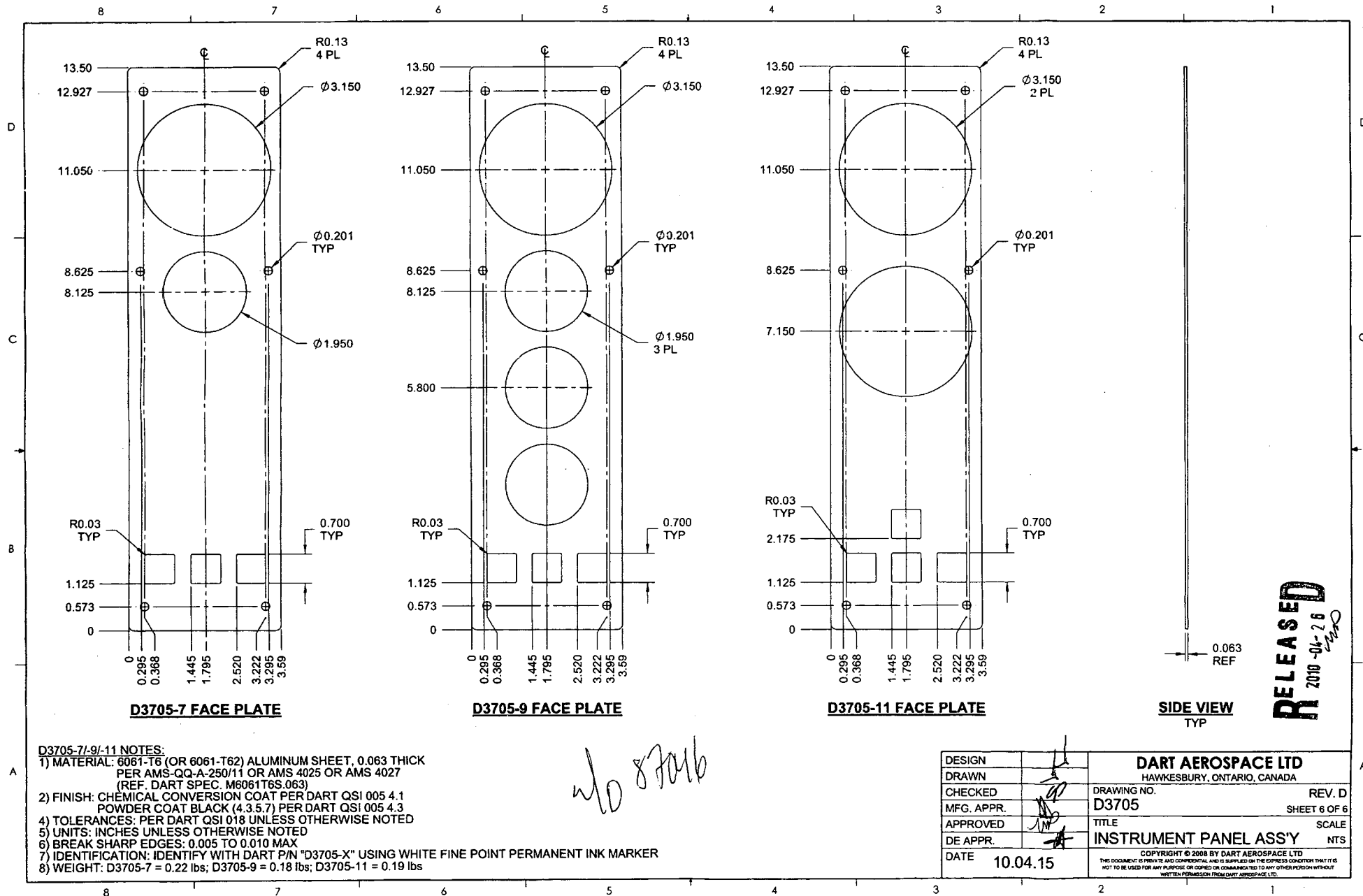
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



RELEASED
N 2010-04-26
VMD

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DART AEROSPACE LTD		Work Order: 87046
Description: MAIN PANEL		Part Number: D3105-11
Inspection Dwg: D3105-11 Rev: D		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 201	+0.05/-0.01	201	L		V RB2	
3.150	±0.010	3.149	L		V	
1700	±0.010	1696	L		V	
295	±0.010	297	L		V	
368	±0.010	377	L		V	
1.445	±0.010	1.453	L		V	
1.795	±0.010	1.795	L		V	
2.520	±0.010	2.528	L		V	
3.222	±0.010	3.226	L		V	
3.295	±0.010	3.295	L		V	
3.59	±0.030	3.600	L		V	
578	±0.010	577	L		V	
1.125	±0.010	1.131	L		V	
2.175	±0.010	2.180	L		V	
7.150	±0.010	7.150	L		V	
8.625	±0.010	8.627	L		PROW302	
11.050	±0.010	11.050	L		P	
12.927	±0.010	12.927	L		T RB01	
13.50	±0.030	13.50	L		T	
1063	±0.010	1063	L		V	

Measured by: RB	Audited by: S	Preliminary Approval:
Date: 12-7-10	Date: 12/02/11	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	